

Work Order ID 85915

June-18-12 2:31:11 PM

85915

Page 1

Item ID: D4006-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Channel

Start Date: 18/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/18

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D4006	B
-------	---

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

2024-06-13

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

4 0 Jm 12-6-23

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

4 0 Jm 12-6-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

4

12/06/12

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

C'sink as per dwg

4

12/06/12

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

5/12/06/12

4

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Start Date: 18/06/2012 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4		261 12-6-27	
160 *160* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00		51716-127		(74)			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location <u>582</u> Memo	0.00 0.00				4x		80 12-6-27.	

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/06/27
MF
12-06-27

Dart Aerospace Ltd

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Picklist Print

June-18-12 2:31:15 PM

Page 1

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85915

Parent Item: D4006-3

D4006-3

Parent Item Name: Channel

Start Date: 18/06/2012

Required Date: 02/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 09.12.22 new Issue Prelim EC verified by:DD IPP Rev:B
10.05.03 as per ECN10-562 DD verified by:EC IPP Rev:C 12.03.07 as
per dwg rev.b DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	268.9700	0.0971	0.408842			

M2024T3S 063

2024-T3 .063 sheet

**

Jun 12-6-23

Location

Loc Qty

Loc Code

MAT022

268.97

119916

73.27

121197

195.7

117392

117392

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Dart Aerospace Ltd

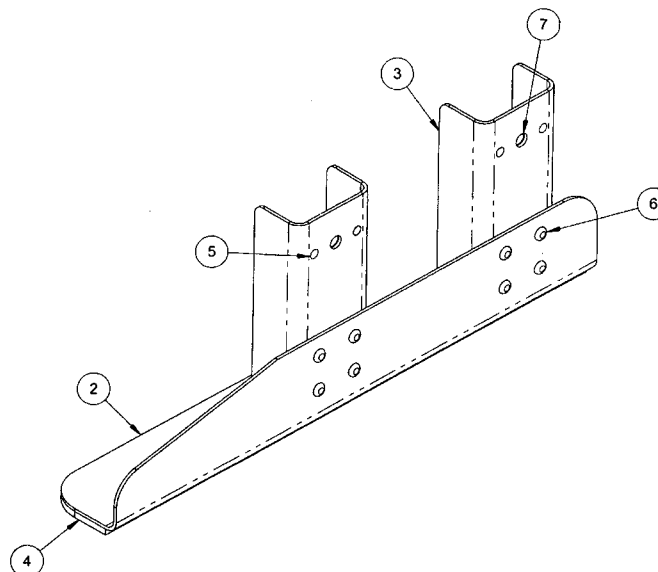
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NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4006-041	TANK TOP SUPPORT ASSEMBLY	JCA-M47-2-01
2	1	D4006-1	ANGLE	
3	2	D4006-3	CHANNEL	
4	1	D4006-5	FOAM	
5	4	MS20426AD3(-4)	RIVET	
6	8	MS20470AD4(-5)	RIVET	
7	2	MS21059-4	ANCHOR NUT	



D4006-041 TANK TOP SUPPORT ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 25915 MLJ
12/06/18

RELEASED
2012-03-02
WJ

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3 BEFORE INSTALLATION OF D4006-5 FOAM AND MS21059-4 ANCHOR NUTS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.48 lbs



B	CHANGE POWDER COAT FROM "GREY SANDEXT" TO "ANSI 61 GREY", ZN A7-1.	DC	12.02.28
A	NEW ISSUE	BY	10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN	DES	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	DES	DRAWING NO.	REV. B
MFG. APPR.	FE	D4006	SHEET 1 OF 6
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	UPPER RESTRAINT	NTS
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W/O:		WORK ORDER CHANGES					
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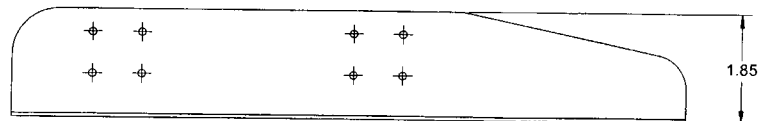
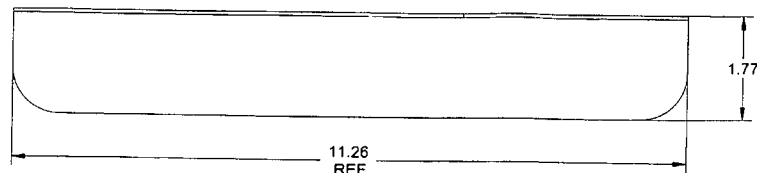
NOTE: Date & initial all entries

DART AEROSPACE
PART NUMBER

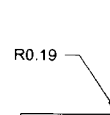
D4006-1

JOHN CAMERON AVIATION
PART NUMBER

REF JCA-M47-2-01



R0.19



D4006-1 ANGLE

RELEASED
2012-03-02
W

NOTES:

- 1) MATERIAL: MADE FROM D4006-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

DESIGN	BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	BC	DRAWING NO. D4006	REV. B
MFG. APPR.	BC	SHEET 2 OF 6	
APPROVED	WJ	TITLE	SCALE
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Dart Aerospace Ltd

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Dart Aerospace Ltd

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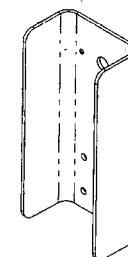
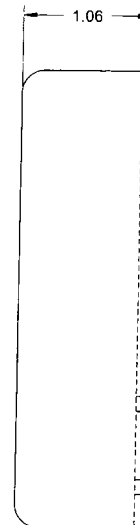
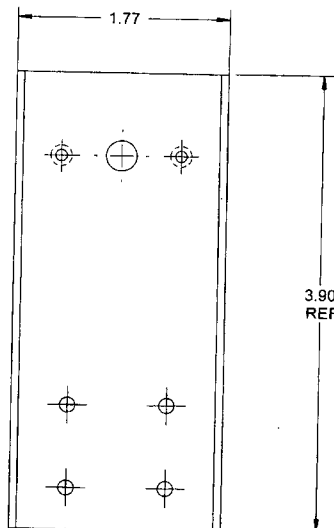
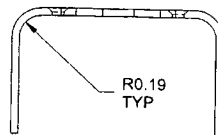
NOTE: Date & initial all entries

DART AEROSPACE
PART NUMBER

D4006-3

JOHN CAMERON AVIATION
PART NUMBER

REF JCA-M47-2-01



D4006-3 CHANNEL

NOTES:

- 1) MATERIAL: MADE FROM D4006-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	<i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>BC</i>		
CHECKED	<i>BC</i>	DRAWING NO. D4006	REV. B
MFG. APPR.	<i>BC</i>	SHEET 4 OF 6	
APPROVED	<i>BC</i>	TITLE	SCALE
DE APPR.	<i>BC</i>	UPPER RESTRAINT	NTS
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RELEASED
2012-03-03
ANN

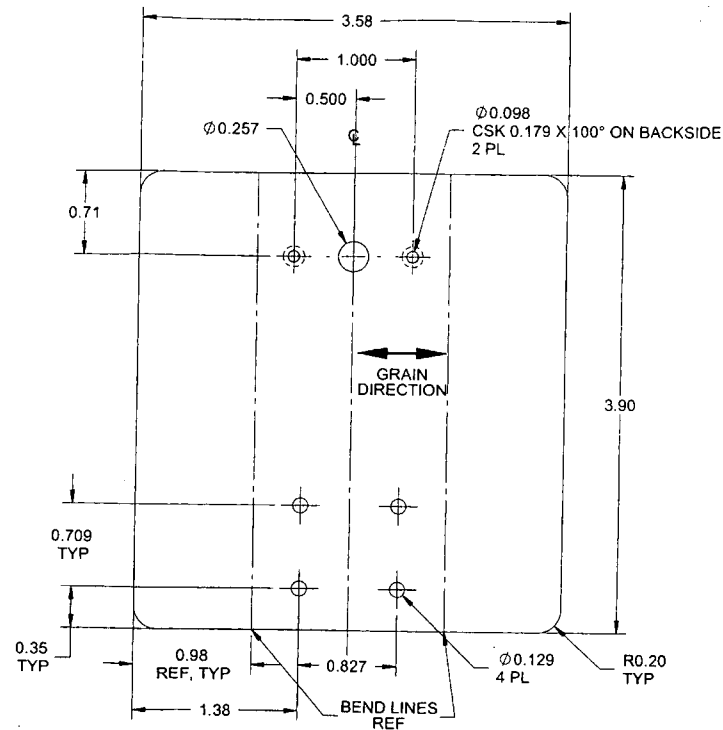
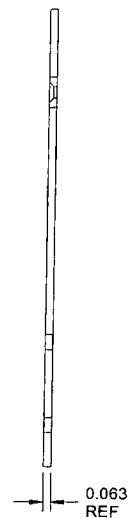
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D4006-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	JS	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	BC	D4006	SHEET 5 OF 6
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2012-03-02

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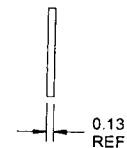
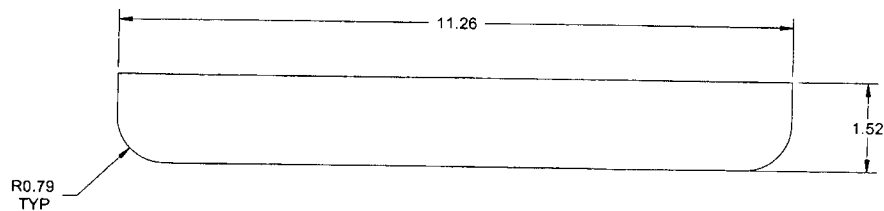
DART AEROSPACE
PART NUMBER

D4006-5

JOHN CAMERON AVIATION
PART NUMBER

REF JCA-M47-2-01

85915



D4006-5 FOAM

NOTES:

- 1) MATERIAL: BLACK NEOPRENE/EPDM/SBR BLEND SHEET, 0.125 THICK
PER ASTM D 1056 GRADE 2A1 OR SAE J-18 GRADE 2A1
REF DART SPEC M-4111N-S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4006	SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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